

CLAIM AMENDMENTS:

Claims 1 to 56 (cancelled)

57. (new) A device for producing a printed useful part and a waste portion residue by punching printed cardboard, cardboard packaging, corrugated board, paper and similar substrates using a rotary punching process, the device comprising:
- a first rotating processing roller;
 - a second rotating processing roller, said second processing roller cooperating with said first processing roller to define a working gap between said first processing roller and said second processing roller;
 - tool parts disposed on at least one of said first processing roller and said second processing roller to process a useful part and a waste portion from the substrate by cooperating with at least one of said first processing roller and said second processing roller to punch out the substrate in said working gap ;
 - at least one gripper disposed on at least one of said first processing roller and said second processing roller, said at least one gripper effecting a register-controlled transport of the substrates as printed sheets, whereby the printed image and processing shape of the subsequent tool parts are thereby superposed in a register-controlled fashion and with improved accuracy;
 - means for splitting off and separating the useful part from the waste portion, wherein the means for splitting off and separating is disposed at the end of the working gap, wherein the means for splitting off and separating include said gripper and means for suctioning and/or pressurized air so that the waste portion is held and removed from the working gap either by said gripper or by means of suctioning and/or pressurized air; and

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at least one disposal device cooperating with the waste transport means for collecting the waste portion.

58. (new) The device of claim 57, wherein said splitting-off and separating means comprise a module member having selectively applicable discharge devices to facilitate a three-fold discharge option with gripper and/or airflow and/or table.
59. (new) The device of claim 57, wherein the means for discharging the substrate without processing or means for discharging a pre-punched intermediate product and means for discharging the waste portion separated from the punched-out useful part and discharging the useful part.
60. (new) The device of claim 57, wherein a downstream gripper acting on the substrates fed from the first processing roller and the second processing roller is disposed at any one of a delivery roller, a transfer roller or a downstream arm.
61. (new) The device of claim 57, wherein the useful part is a punched-out product or a punched sheet.
62. (new) The device of claim 57, wherein at least the substrates without punching or with pre-punching are transported in a register controlled fashion.
63. (new) The device of claim 57 wherein the device is integrated in a processing line such that it is register controlled and at least an auxiliary device is provided in the work cycle of the processing line before or after the device.

64. (new) The device of claim 57, wherein said first and said second processing rollers bear said tool parts in an exchangeable manner.
65. (new) The device of claim 57, further comprising a laser punching unit disposed proximate said working gap.
66. (new) The device of claim 57 wherein said gripper is a mechanical gripper
67. (new) The device of claim 64, wherein said first and/or said second processing rollers comprise magnetic cylinders on which said tool parts are held in an exchangeable fashion, said tool parts comprising at least one of punching, stamping, furrowing and embossing tools.
68. (new) The device of claim 57, further comprising a downstream disintegrating means.
69. (new) The device of claim 69, wherein said disintegrating means cooperates with said disposal device via transport pipes.
70. (new) The device of claim 69, wherein said disintegrating means is connected to a waste bin via transport pipes.
71. (new) The device of claim 69, wherein said disintegrating means is disposed outside or inside a machine.
72. (new) The device of claim 57, wherein a plurality of disposal devices are provided for disposal of the waste portion.
73. (new) The device of claim 57, wherein said plurality of disposal devices are structured and positioned for disposal of the waste

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portion at a surface and/or inner portions of said first and said second processing rollers.

74. (new) The device of claim 57, wherein said plurality of disposal devices are structured for disposal of the waste portion through further transport using a second down stream gripper.

75.(new) The device of claim 57, wherein at least one of said first and said second processing cylinders is a hollow cylinder suitable for transporting the waste portion.